

Date: Thursday, 5/4/2006 11:14:44 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SHUT-OFF VALVE BRACKET |
| Job Number : 26962 | |
| Estimate Number : 12256 | |
| P.O. Number : N/A | Part Number : D3481041 |
| This Issue : 5/4/2006 S.O. No. : N/A | Drawing Number : D3481 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL / MED FAB | Drawing Revision : A |
| Previous Run : 26855 | Material : N/A |
| Written By : <i>See comment below</i> | Due Date : 5/28/2006 Qty: <u>2</u> 8 Um: Each |
| Checked & Approved By : <i>06-05-05</i> | |
| Comment : Est Rev: A New Issue 06-02-03 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|-----------------------|
| 1.0 | D3481043 | bracket & clamp ass'y |
|-----|----------|-----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| | | | |
|-----|-------------|------------------|-----------|
| Qty | Part Number | Description | Batch |
| 1 | D3481-3043 | Bracket Assembly | B27 002 ✓ |

| | | |
|-----|-----------|-------------------|
| 2.0 | BACN10YD3 | CLIP FLOATING NUT |
|-----|-----------|-------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|----------|
| Qty | Part Number | Description | Batch |
| 4 | BACN10YD3 | Clip | M19596 ✓ |

| | | |
|-----|-------|------|
| 3.0 | AN33A | Bolt |
|-----|-------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|-----------|
| Qty | Part Number | Description | Batch |
| 4 | AN3-3A | Bolt | M100117 ✓ |

| | | |
|-----|---------|--------|
| 4.0 | AN96010 | Washer |
|-----|---------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part Number | Description | Batch |
| 4 | AN960-10 | Washer | M5519 ✓ |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *Q* Date: *04/05/25*
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:14:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE BRACKET

Job Number: 26962

Part Number: D3481041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34811

ANGLE BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3481-1

Bracket

B 24105

SB 06/05/18

(2)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

SB 06/05/18

(2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/05/23

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a fine point permanent marker and Stock

Location: _____

ST444

06/05/23

(2)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/25

(2)

Job Completion



U 06-05-25

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

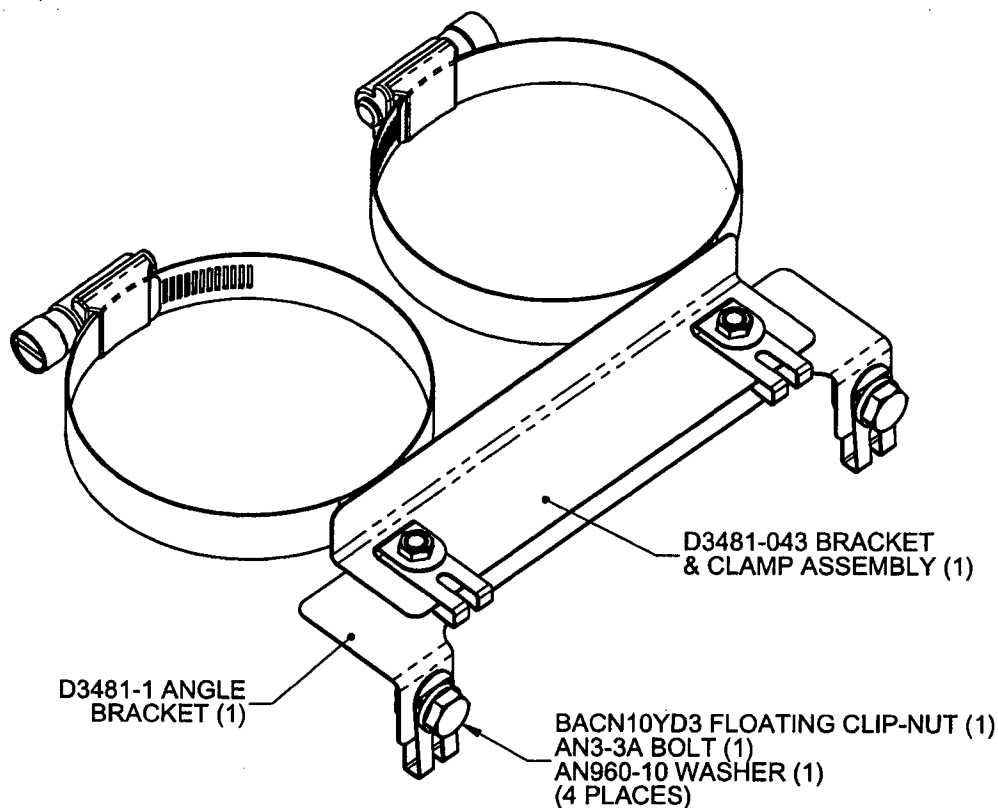
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|----------------------|--|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3481 | REV. A SHEET 1 OF 4 |
| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 2:3 |
| A | 06.01.23 | NEW ISSUE | |

06.04.03**D3481-041 SHUT-OFF VALVE BRACKET**

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|--------------------------|
| X | D3481-041 | SHUT-OFF VALVE BRACKET |
| 1 | D3481-043 | BRACKET & CLAMP ASSEMBLY |
| 1 | D3481-1 | ANGLE BRACKET |
| 4 | AN3-3A | BOLT |
| 4 | AN960-10 | WASHER |
| 4 | BACN10YD3 | FLOATING CLIP-NUT |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26962*

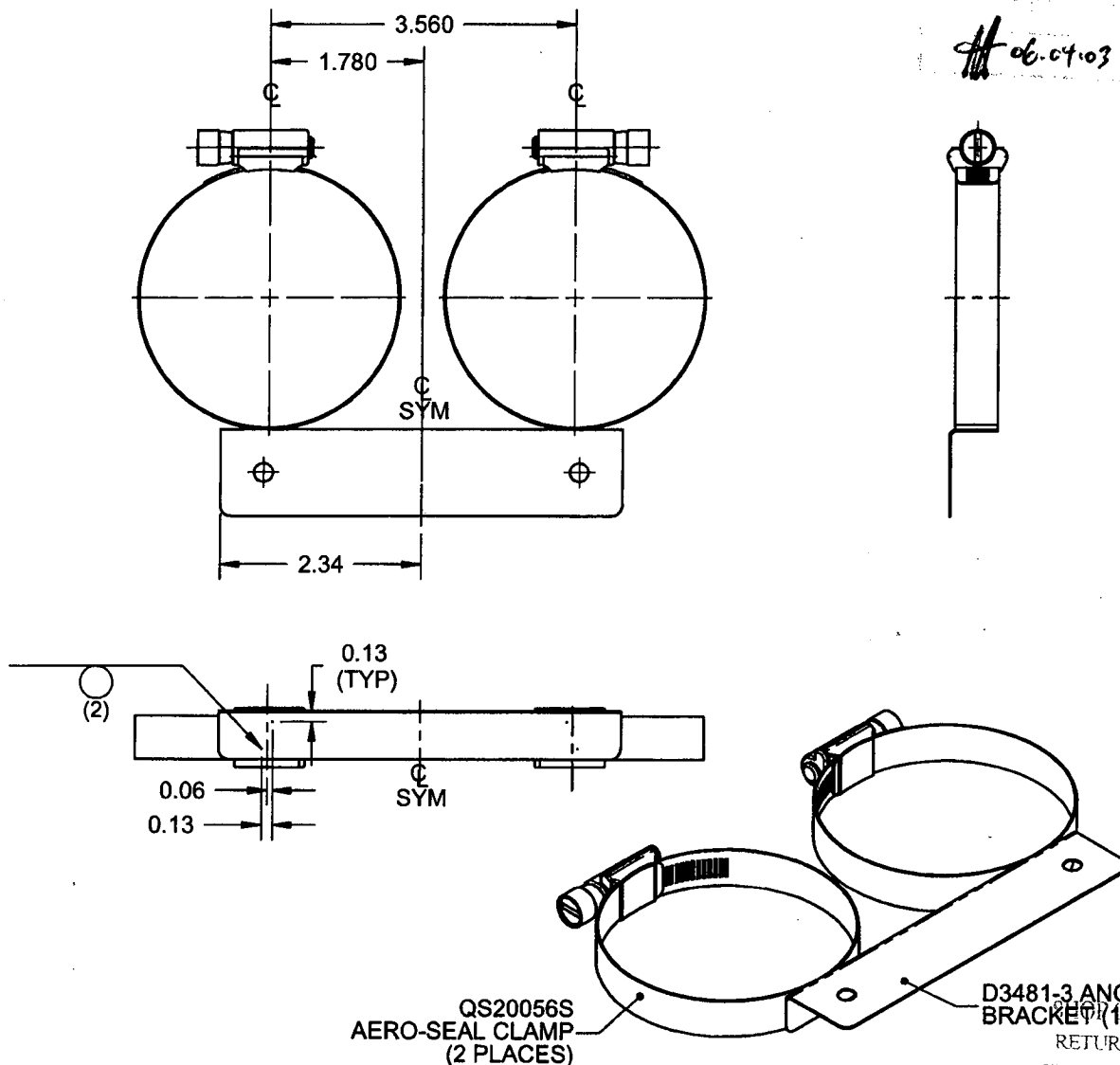
COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3481 | REV. A SHEET 2 OF 4 |
| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 1:2 |



D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

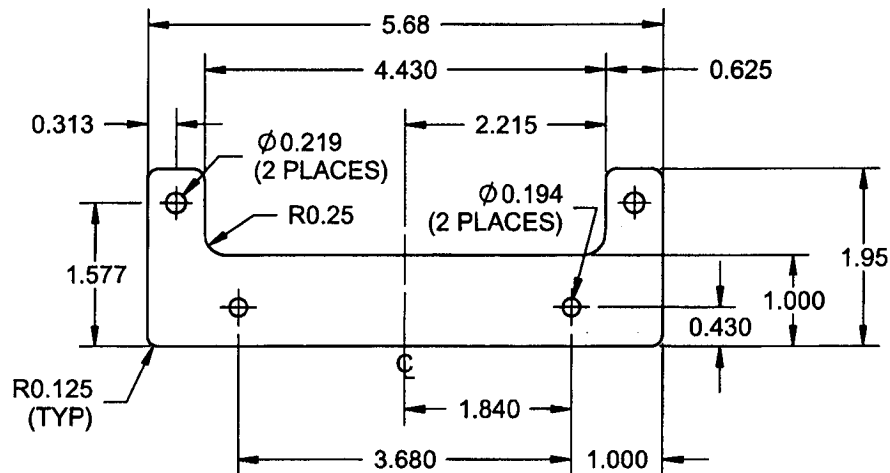
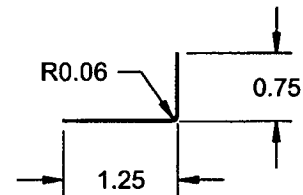
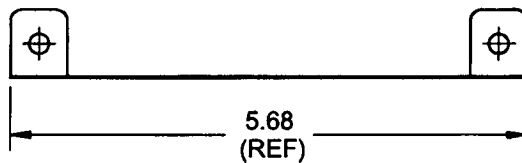
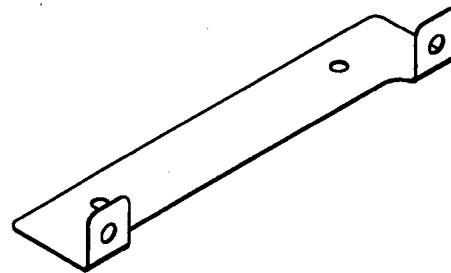
| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|--------------------------|
| X | D3481-043 | BRACKET & CLAMP ASSEMBLY |
| 1 | D3481-3 | ANGLE BRACKET |
| 2 | QS20056S | AERO-SEAL CLAMP |

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3481 | REV. A SHEET 3 OF 4 |
| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 1:2 |

**D3481-1F FLAT PATTERN****D3481-1 ANGLE BRACKET***[Signature]* 06.04.03**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26962*

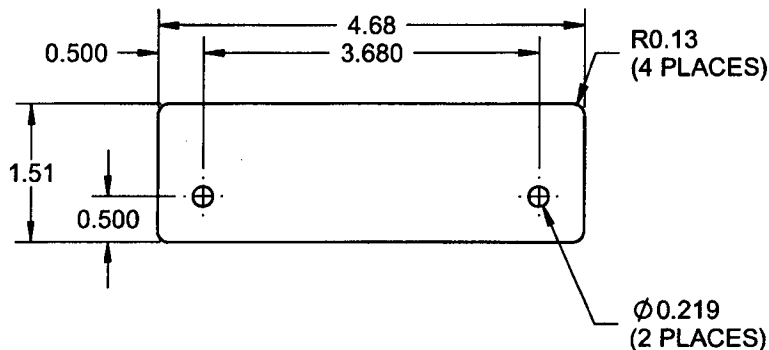
COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

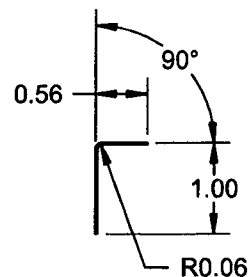
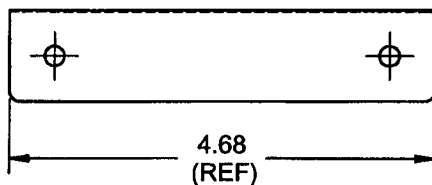


| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3481 | REV. A SHEET 4 OF 4 |
| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 1:2 |

H 06.04.03



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *26962*

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.